



DESIGN <i>GP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>B</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3288	REV. D SHEET 1 OF 3
DATE 07.06.04		TITLE SKIDTUBE ASSEMBLY	SCALE NTS
A	04.05.17	NEW ISSUE	
B	05.03.16	CHANGE INSERTS	
C	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET	
D	07.06.04	DIMENSIONS ADDED	

RELEASED
07-08-27 PM
PER ECN 959

UNDER REVIEW
07.06.04
GHW BSE
(COMPLIANCE)

Qty -041	Part Number	Description
X	D3288-041	SKIDTUBE ASSEMBLY
1	D2600-1-240	EXTRUSION
1	D2647	CAP
1	D2646	AFT CAP
9	D2649	CROSS BOLT SPACER
9	D3275-1	CROSS BOLT SPACER
2	D3286-1	DOUBLER
2	D3286-3	SPACER
1	D3289-041	FLOAT WEB
1	D3413-1	RING
1	D3415-041	NUT PLATE
1	D3535-15	WEARSHOE
1	D3535-21	WEARSHOE
1	D3535-35	WEARSHOE
1	D3535-41	WEARSHOE
1	D3536-15	GASKET
1	D3536-21	GASKET
1	D3536-35	GASKET
1	D3536-41	GASKET
7	D3537-1	WEARPAD
1	D3537-3	WEARPAD
64	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
66	AN3C4A	BOLT
1	AN4C5A	BOLT
1	AN960C416	WASHER
66	AN960C10L	WASHER
2	CCR264SS3-3	RIVET
2	CR3212-4-03	RIVET
52	CR3212-4-04	RIVET
2	NAS1515H3L	WASHER

GENERAL NOTES:

- FINISH:
 - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
 - POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.
- DAMAGE TOLERANCE ON FWD BEND:






THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- BOND D3289-041 FLOAT WEB INTO D3288-1 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- ALL HOLES DRILLED ON CENTERLINES.
- DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3288-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291.
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- WELDING TO BE DONE PER DART QSI 004.

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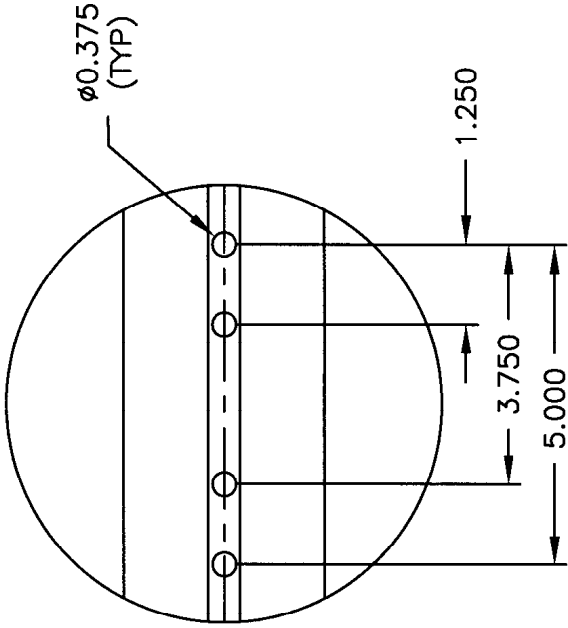
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UNDER REVIEW
07.09.2013
GAW BSE
(COMPATIBILITY)



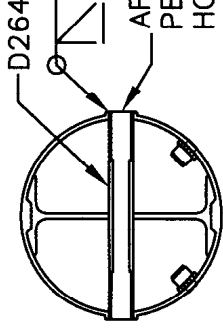
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		CHECKED 		APPROVED 		DRAWING NO. D3288					
		DATE 07.06.04				TITLE SKIDTUBE ASSEMBLY					

DETAIL A: DRILL DETAIL



DETAIL B

FOR Ø0.375 HOLES ONLY

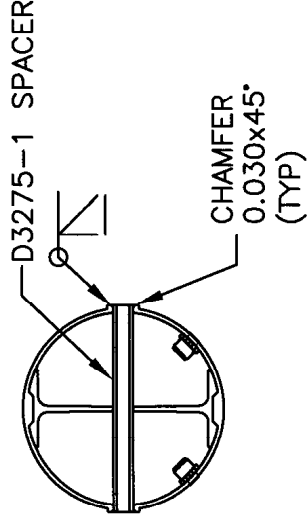


AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:

1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C

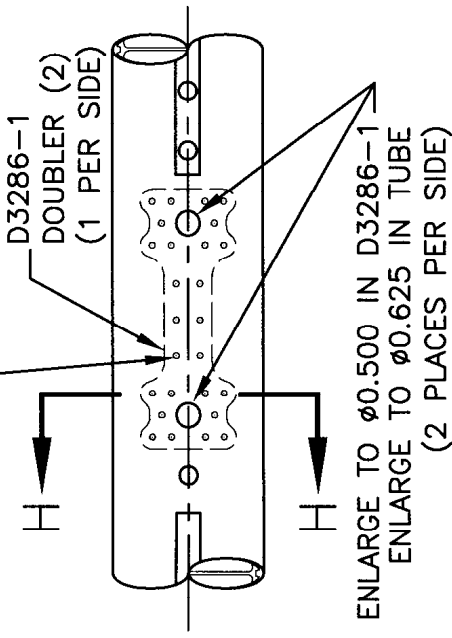
FOR Ø0.313 HOLES ONLY



DETAIL G

SCALE 1:5

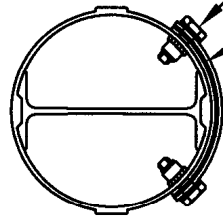
DRILL #30
C'SINK Ø0.229x100"
INSTALL CR3212-4-04
RIVET (26 PER DOUBLER)



ENLARGE TO Ø0.500 IN D3286-1
ENLARGE TO Ø0.625 IN TUBE
(2 PLACES PER SIDE)

UNDER REVIEW
07.06.04
GAW DSW
(COMPATIBILITY)

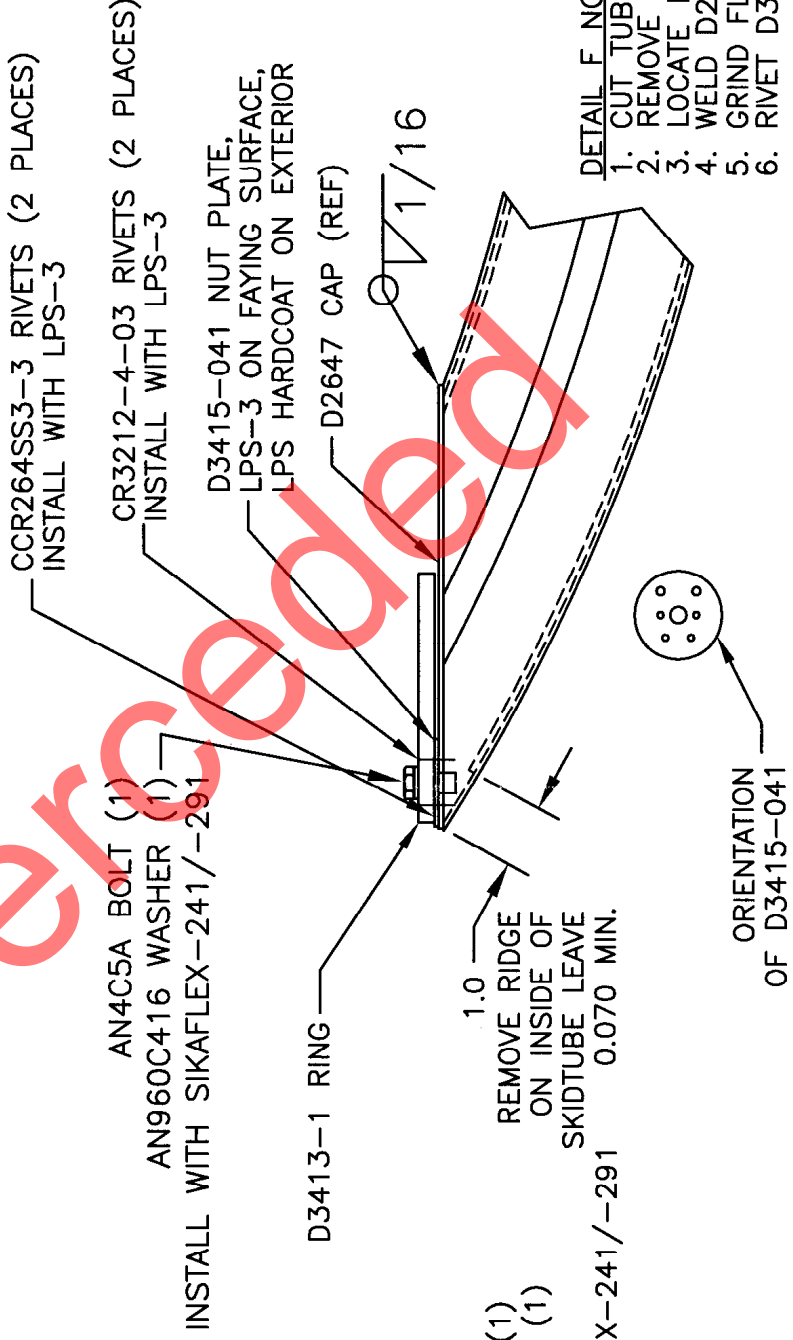
DETAIL D



- ALS7-1032-130 INSERT (1)
- AN3C4A BOLT (1)
- AN960C10L WASHER (1)
- (64 PLACES)

GASKET/WEARSHOE/WEARPAD (REF)

DETAIL F: END FINISHING DETAIL



CCR264SS3-3 RIVETS (2 PLACES)
INSTALL WITH LPS-3

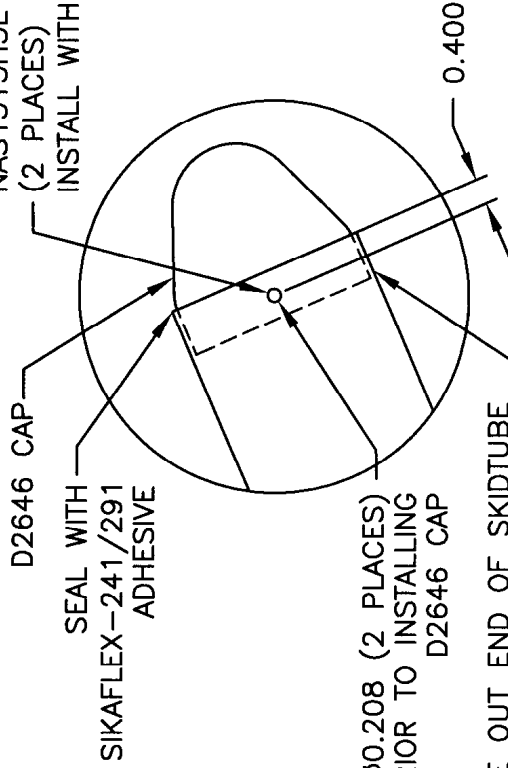
AN4C5A BOLT (1)
AN960C416 WASHER (1)
INSTALL WITH SIKAFLEX-241/-291

D3413-1 RING

D3415-041 NUT PLATE,
LPS-3 ON FAYING SURFACE,
LPS HARDCOAT ON EXTERIOR

AN3C4A BOLT (1)
AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)
INSTALL WITH SIKAFLEX-241/-291

DETAIL E

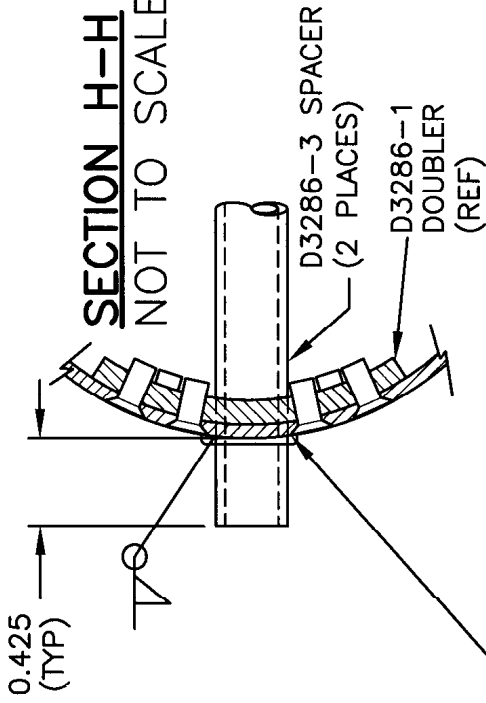


D2646 CAP
SEAL WITH
SIKAFLEX-241/291
ADHESIVE

Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

SECTION H-H
NOT TO SCALE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

DETAIL F NOTES

1. CUT TUBE LEVEL
2. REMOVE RIDGE ON FWD SIDE
3. LOCATE D2647 (TRIM AS NECESSARY)
4. WELD D2647 IN PLACE PER DART QSI 004
5. GRIND FLUSH
6. RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

RIGHT TO REVIEW
07.06.04

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		DATE		D3288	SHEET 3 OF 3
				TITLE	SCALE
				SKIDTUBE ASSEMBLY	1:3